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DART AEROSPACE LTD	Work Order:	20738
Description: Bracket	Part Number:	D3146-2
Dwg: D3146 Rev. A	Qty:	10 Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.04.29	10
2	MV	Cut blanks: 4.500" x 1.250" x 3.100" long Bar Material: 6061-T6/T651 (QQ-A-200/8) 1.250" thick (M6061T6B1.250x04.500) Identify for D3146-2	GD	04/05/29	10
3	MV	Machine as per Folio FA419 and Dwg D3146 Identify as D3146-2	SP	04/06/01	10
4	QC2	Inspect parts as they come off the CNC machine	SP	04/06/01	10
5	QC8	Second check	PZ	04.06.09	10
6	MV	Deburr and Tumble	PZ	04.06.16	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1	JML	04.06.11	10
8	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	JML	04.06.17	10
9	QC3	Inspect Powder Coat	JML	04.06.17	10
10	QC5	Inspect work to Step 9	Ban	04.06.17	10
11	ST	Identify and Stock in Spacedoor Cell	CDP	04/06/17	10
12	AC	Cost / part <u>31.68</u>	SAC	04.06.18	10
13	DC	Close W/O <u>35.21</u> Inspect Level 21	KJ	04.06.21	10

Rev	Date	Change	Revised By	Approved
A	04.04.28	New issue	KJ/JLM	Jeff.

RELEASED

04.04.29

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 20738		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
04.06.01	3	.125 measurement is at .110 - only at one end of part. 3 parts affected	#	Acceptable this time only.	NA 04.06.01	BB 04.06.01	# 04.06.01	B 04.06.01

PAR#: N/A Fault Category: Manuf-CNC DQA: BB

Date: 04.06.21

QA: N/C Closed: BB

Date: 04.06.22

DRAFT
ISSUED

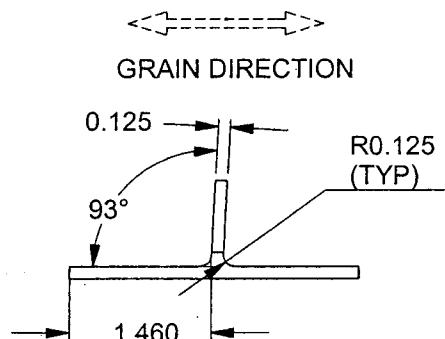
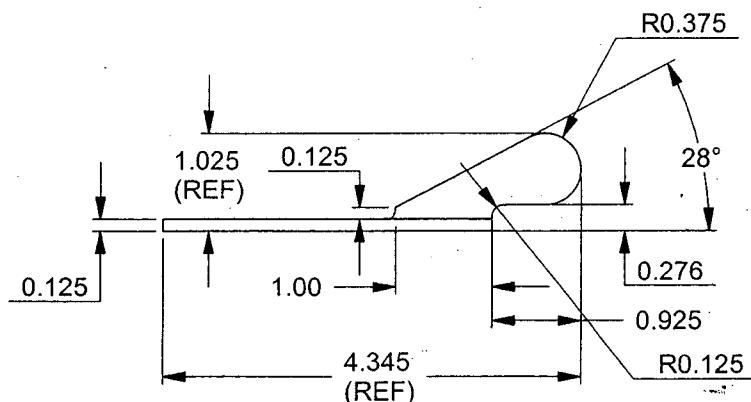
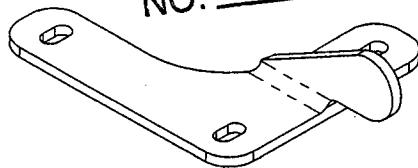
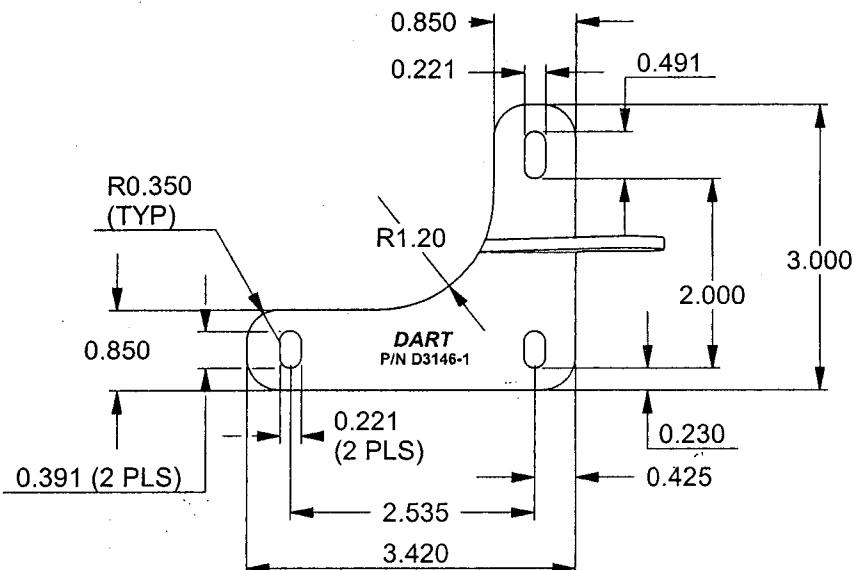
DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3146	REV. A SHEET 1 OF 1
DATE 02.04.25		TITLE BRACKET	SCALE 1:2

RELEASED
02.05.27

A 02.04.25

NEW ISSUE

SHOP COPY

RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 20738

D3146-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-27
(D3146-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-28)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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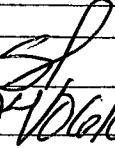
DART AEROSPACE LTD		Work Order:	20738
Description:	Bracket	Part Number:	D3146-2
Inspection Dwg:	D3146	Rev:	A

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.000	+/-0.010	3.002	✓			
2.000	+/-0.010	2.000	✓			
0.230	+/-0.010	0.232	✓			
0.425	+/-0.010	0.422	✓			
3.420	+/-0.010	3.422	✓			
2.535	+/-0.010	2.535	✓			
0.221	+/-0.010	0.220	✓			
0.391	+/-0.010	0.391	✓			
0.221	+/-0.010	0.220	✓			
0.850	+/-0.010	0.850	✓			
R0.350	+/-0.010	0.350	✓			
0.850	+/-0.010	0.848	✓			
0.221	+/-0.010	0.220	✓			
0.491	+/-0.010	0.491	✓			
0.125	+/-0.010	0.125	✓	✓		
1.025	+/-0.010	1.025	✓			
R0.375	+/-0.010	0.375	✓			
28°	+/-0.1°	28°	✓			
0.276	+/-0.010	0.272	✓	✓		
0.925	+/-0.010	0.925	✓			
R0.125	+/-0.010	0.125	✓			
4.345	+/-0.010	4.343	✓			
0.125	+/-0.010	0.126	✓			
93°	+/-0.1°	93°	✓			
R0.125	+/-0.010	0.125	✓			
Grain Direction	N/A					

PRELIMINARY ISSUE

Measured by:		Audited by:		Prototype Approval:	
Date:	04/06/01	Date:	04/06/01	Date:	04-06-01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 20, 2004
02:46 pm

Work Order No : 0020738
 Project Name : D3146-2
 Project For : WK420
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3146-2
 Description : Hinge Bracket
 Manufactured : No
 Amount Req'd : *0/10*
 Amount Done : 0
 Start Date : 04-20-04
 Est Finish Date : 05-10-04
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00